



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3146-2
Job Sheet 209441



Part No: D3146-2

Job Qty: 2 pcs

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/30/20

Job Tracking No:

Due Date: 5/12/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP A 04.04.28 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	2 pcs		5/11/20	0.00	2.48	Bandsaw - 1		ALA/ma L 20/05/04
110	HAAS 4 Axis - B4B	2 pcs		5/11/20	1.00	2.48	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		mm L 20/05/12
120	QC 2	2 pcs		5/11/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		mm L 20/05/13
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S277577



Part: D3146-2

Job No: 209441

Serial No/Batch: S277577

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/13/20

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130 QC 8	2 pcs	5/11/20	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
150 Handfinish - 1-1 Chemical- B4B	2 pcs	5/11/20	0.00 0.08	QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 -	

8F20-05-13

3FB20-05-13

https://www.plexonline.com/e7340895-e70a-42a0-8c72-9cd7a68ee63b/Plexus_Control/Report_Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=Tr... 3/5

190 Packaging 3-1 - Stock - B4B	2 pcs	5/12/20	0.00 0.00	QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	MAY 13 2020 DAS 40
				QC 5 - 81	9-89
				QC 5 - 82	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	9-89 DAS 69
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
200 QC 21 - SA	2 pcs	5/12/20	0.00 0.00	Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				QC 21 - SA - 21	DAS 21 MAY 13 2020
				QC 21 - SA - 70	9-89
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blanks: 4.500" x 1.250" x 3.100" long Bar
 Descriptions: 110 - (HAAS CNC Vertical Machine) Machine as per Folio FA419 and Dwg D3146 Identify as D3146-2
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 150 - Chemical Conversion Coat per QSI005 4.1
 160 - (White Gloss (Ref 4.3.5.1) per QSI005 4.3-Alum) START TIME: 12:45 M754469. OVEN TEMPERATURE: 320°
 FINISH TIME: 1:15
 170 - QC3- Inspect Part Finish
 180 - QC5- Inspect part completeness to step on W/O
 190 - (Identify as per dwg & Stock Location: CAA1 Location : CA2
 200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X4.500	6061-T6 Bar 1.25 X 4.50	.6000 ft (.3 ea)	100-Bandsaw - 1	S250475

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X4.500	1	11	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	3.000inches $\pm$ 0.010	3.010 2.990	3.004	
2	Bracket	2.000inches $\pm$ 0.010	2.010 1.990	1.995	
3	Bracket	0.230inches $\pm$ 0.010	0.240 0.220	.230	
4	Bracket	0.425inches $\pm$ 0.010	0.435 0.415	.427	
5	Bracket	3.420inches $\pm$ 0.010	3.430 3.410	3.426	
6	Bracket	2.535inches $\pm$ 0.010	2.545 2.525	2.530	
7	Bracket	0.221inches $\pm$ 0.010	0.231 0.211	.225	
8	Bracket	0.391inches $\pm$ 0.010	0.401 0.381	.391	
9	Bracket	0.221inches $\pm$ 0.010	0.231 0.211	.225	
10	Bracket	0.850inches $\pm$ 0.010	0.860 0.840	.853	
11	Bracket	0.350inches $\pm$ 0.010	0.360 0.340	Radius .350	
12	Bracket	0.850inches $\pm$ 0.010	0.860 0.840	.850	
13	Bracket	0.221inches $\pm$ 0.010	0.231 0.211	.224	
14	Bracket	0.491inches $\pm$ 0.010	0.501 0.481	.492	
15	Bracket	0.125inches $\pm$ 0.010	0.135 0.115	.126	
16	Bracket	1.025inches $\pm$ 0.010	1.035 1.015	1.016	
17	Bracket	0.375inches $\pm$ 0.010	0.385 0.365	Radius .375	
18	Bracket	28.000Degrees $\pm$ 0.500	28.500 27.500	28.0	
19	Bracket	0.276inches $\pm$ 0.010	0.286 0.266	.276	
20	Bracket	0.925inches $\pm$ 0.010	0.935 0.915	.926	
21	Bracket	0.125inches $\pm$ 0.010	0.135 0.115	Radius .125	
22	Bracket	4.345inches $\pm$ 0.010	4.355 4.335	4.347	
23	Bracket	0.125inches $\pm$ 0.010	0.135 0.115	.125	
24	Bracket	93.000Degrees $\pm$ 0.500	93.500 92.500	93.5	
25	Bracket	0.125inches $\pm$ 0.010	0.135 0.115	Radius .125	

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____ Date : _____	Sequence #: _____ Description Work Order Deviation	QTY Affected : _____ Disposition	DEPARTMENT/PROCESS Skid-tube Machining Large Fab Cross tube Small Fab Finishing Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality	MRB (QS1042)																																																
Root Cause		FAULT CATEGORY																																																		
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